

Work Order ID 53829

November 19, 2009 8:39:33 AM

Page 1

Item ID: D4013-9

Revision ID:

Item Name: Stud

Start Date: 11/19/2009 Start Qty: 40.00

Required Date: 11/23/2009 Req'd Qty: 40.00

Reference:

Approvals:

Process Plan: CMK

Date: 09-11-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4013

C

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

turn as per Dwg and Folio FA860

Folio Rev: N/A

Dwg Rev: C

Deburr

0.00

SA 09/11/22

41

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

SA 09/11/22

41

DEFINITIVE ISSUE

Accept



Setup Start



Stop



Cust Item ID:

Customer:



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4013-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Stud

Start Date: 11/19/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 11/23/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

MA 09/11/22

41

Ø

Quality Control

130

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

u 09.11.23

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u 09.11.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 19, 2009 8:39:33 AM

Page 1

Work Order ID: 53829

Parent Item: D4013-9

Parent Item Name: Stud


Comments: IPP REV:A NEW ISSUE 09-11-03 JLM VERIFIED BY:DD IPP
RevB: revC as per dwg 09.11.18 DD verified by:JLM

Start Date: 11/19/2009

Required Date: 11/23/2009

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	36.4835	5.6842			
												
304 ROUND BAR 0.375												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	36.48347895	
110166	3.32	
110472	6.41	
112058	0.31317895	
112473	26.4403	

304 Round Bar 0.500

M 113006

5.9842

For 11.23
this batch only.

EN 02/11/22

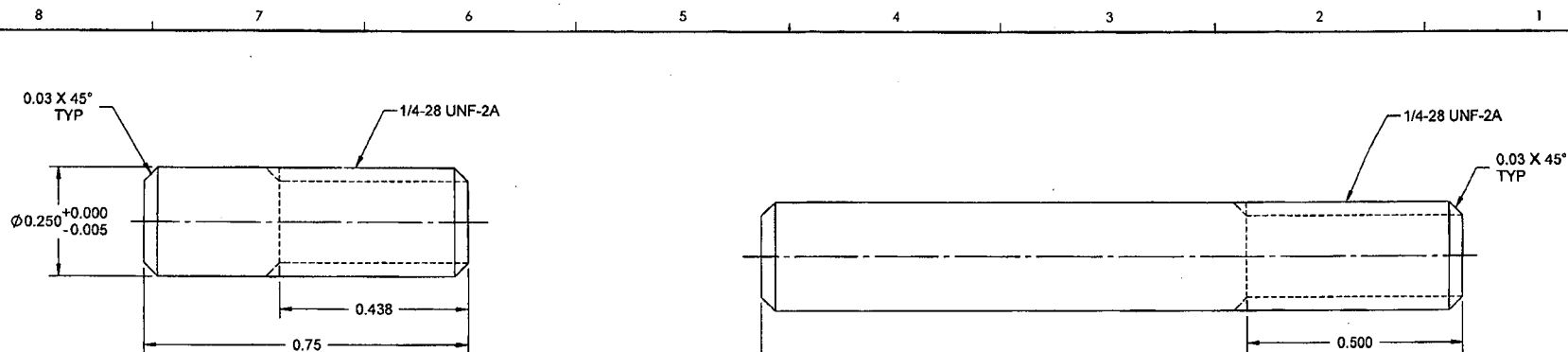
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

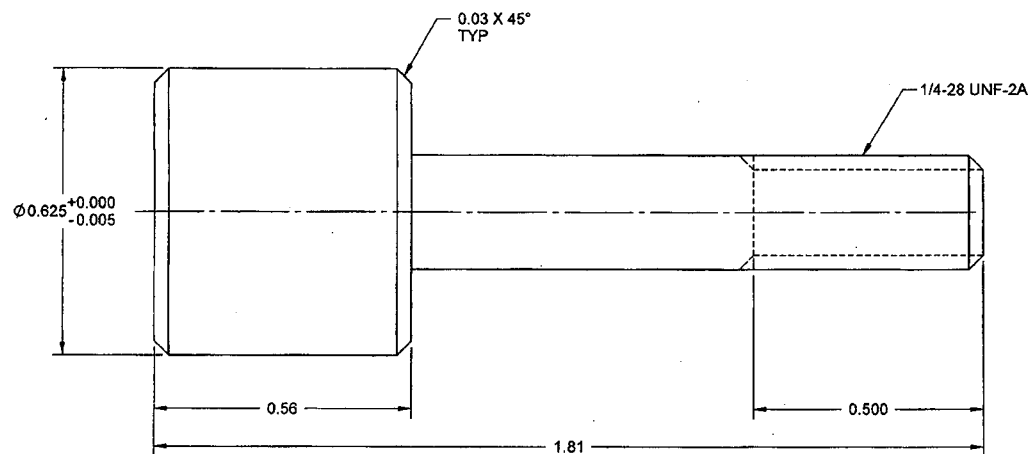
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4013-3 STUD

D4013-9 STUD



D4013-11 STUD

53829

PRELIMINARY ISSUE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
REF. DART SPEC. M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: LESS THAN 0.01 lbs EACH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO. D4013	REV. C
MFG. APPR.	DS		SHEET 4 OF 5
APPROVED	MS	TITLE WEARPLATE ASSEMBLY	SCALE
DE APPR.			NTS
DATE	09.11.11	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

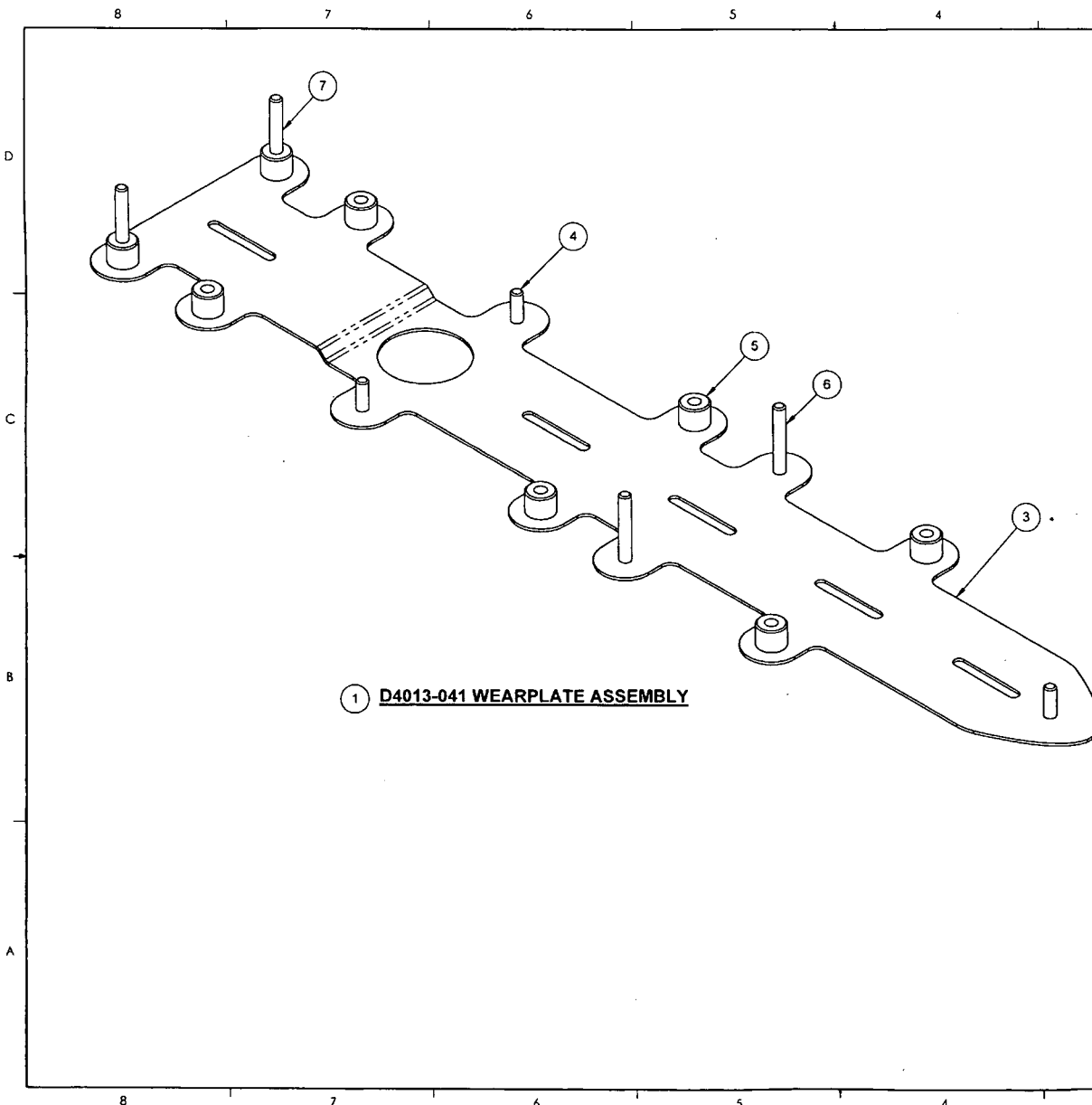
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



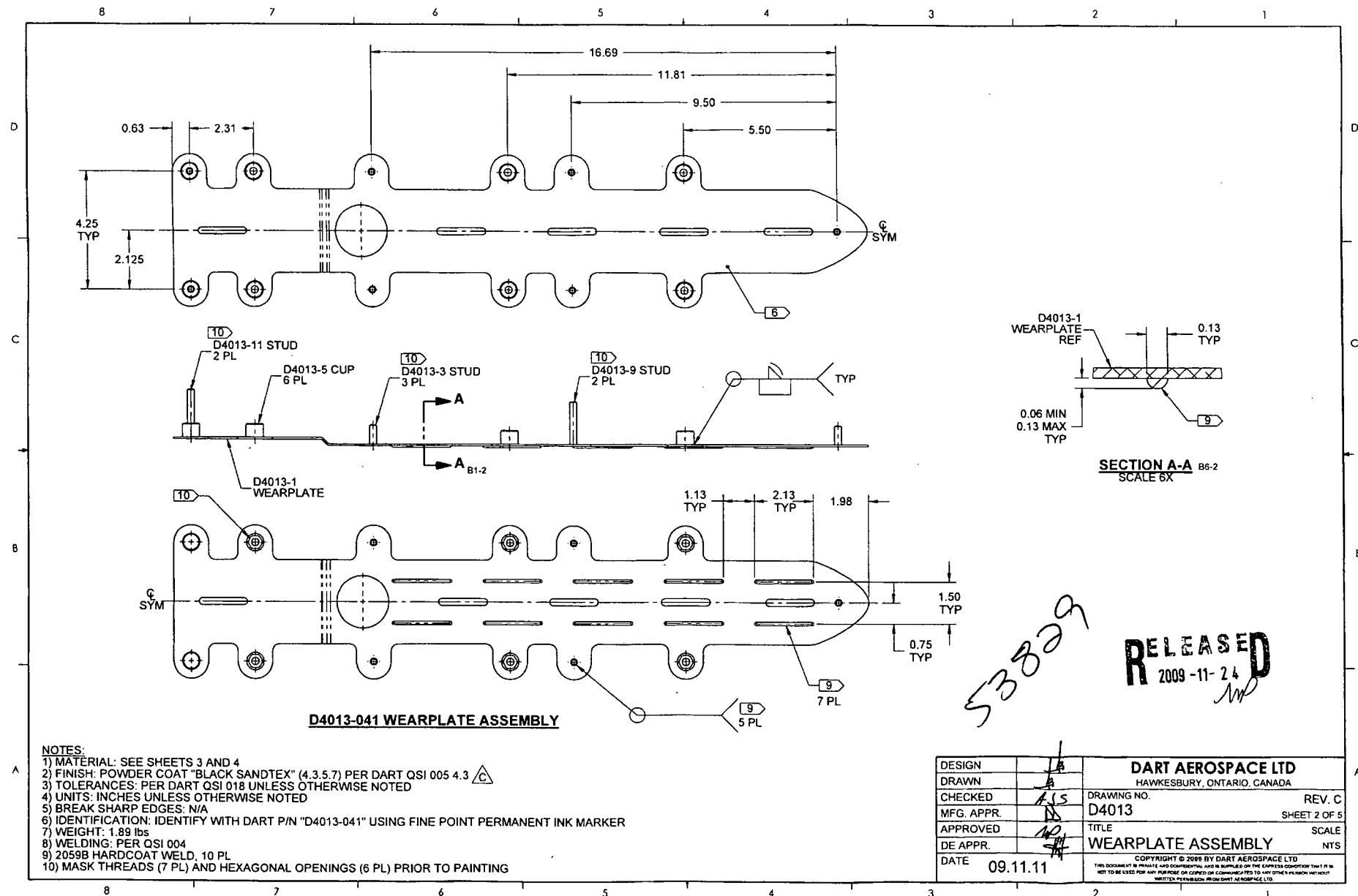
① D4013-041 WEARPLATE ASSEMBLY

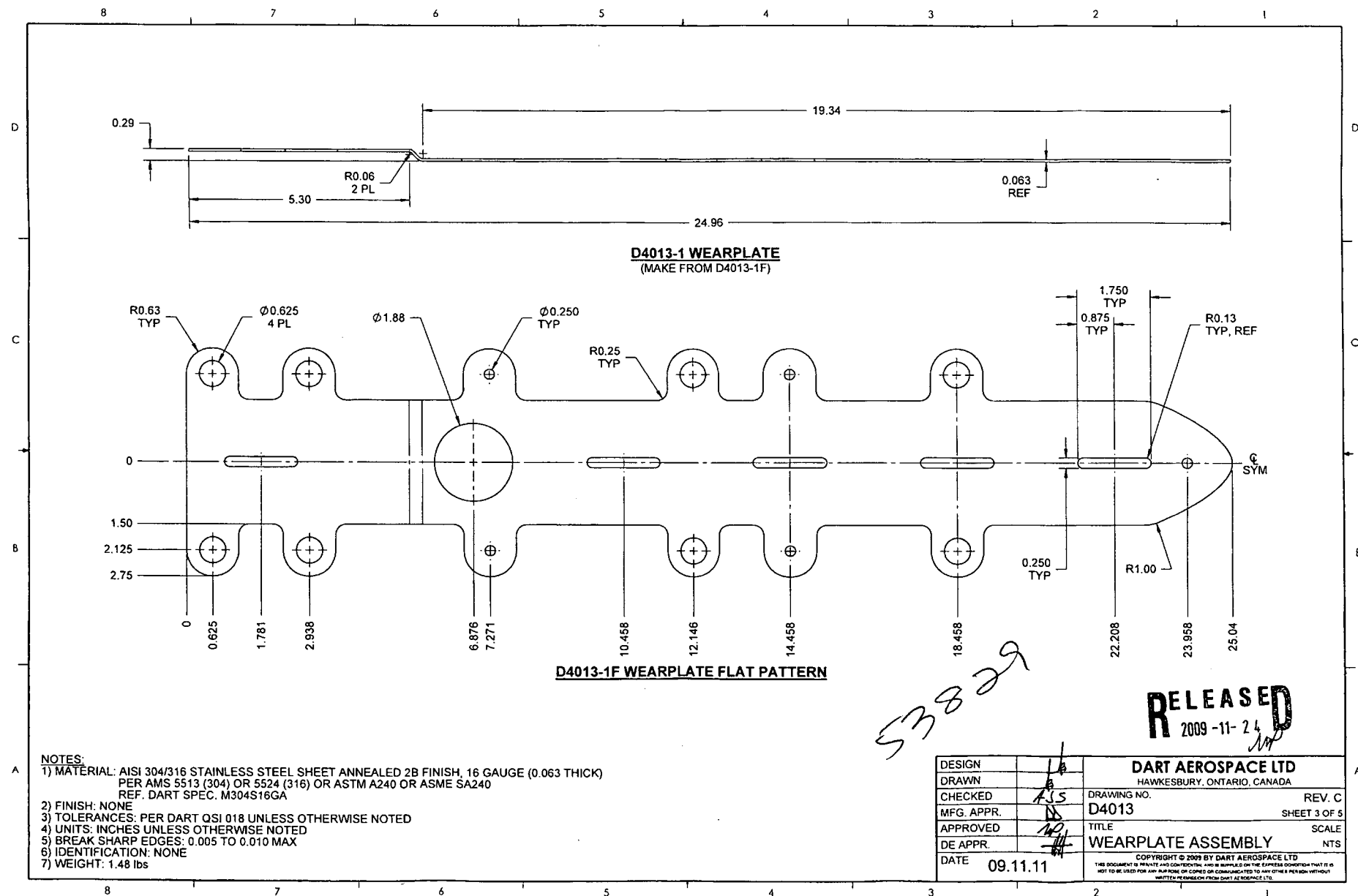
ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4013-041	WEARPLATE ASSEMBLY
3	1	D4013-1	WEARPLATE
4	3	D4013-3	STUD
5	6	D4013-5	CUP
6	2	D4013-9	STUD
7	2	D4013-11	STUD
21	A/R	20598	HARDCOAT

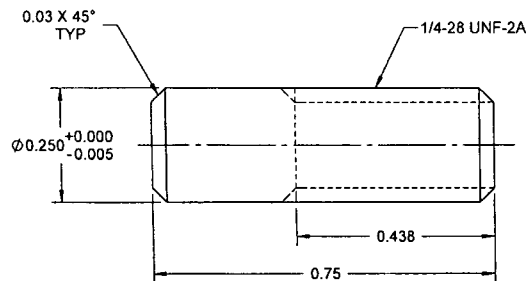
53829

RELEASED
R 2009-11-24
MP

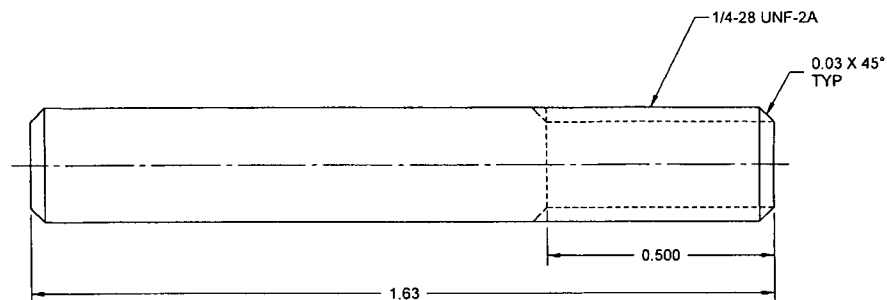
C	SIMPLIFY DESIGN FOR MANUFACTURING PURPOSES; REDESIGNED ITEM 5; ELIMINATED D4013-7 CUP (NO LONGER USED); CHANGED FINISH FROM GREY TO BLACK SANDEK	MB	09.11.11
B	REDESIGN	MB	09.11.02
A	NEW ISSUE	MB	09.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	LA		
DRAWN	AS		
CHECKED	AS		
MFG. APPR.	AS		
APPROVED	AS		
DE APPR.	AS		
DATE	09.11.11		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4013 TITLE WEARPLATE ASSEMBLY REV. C SHEET 1 OF 5 SCALE NTS <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			



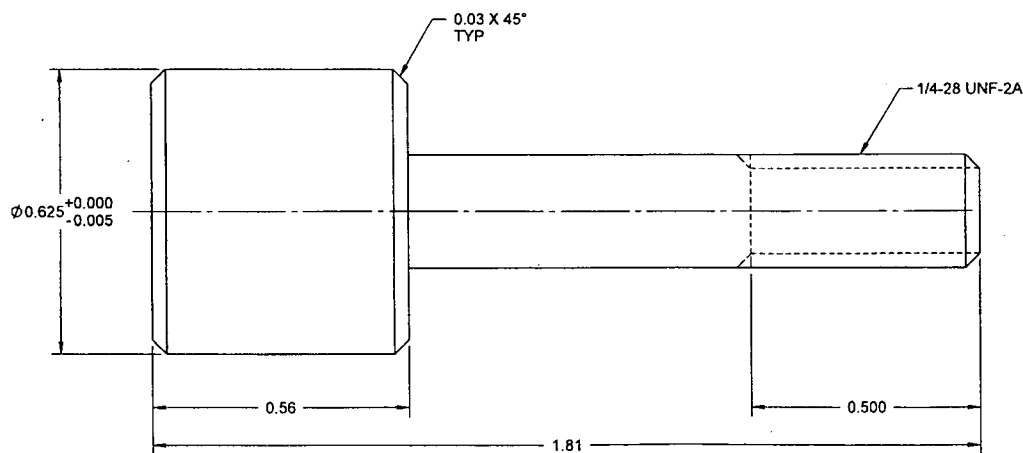




D4013-3 STUD



D4013-9 STUD



D4013-11 STUD

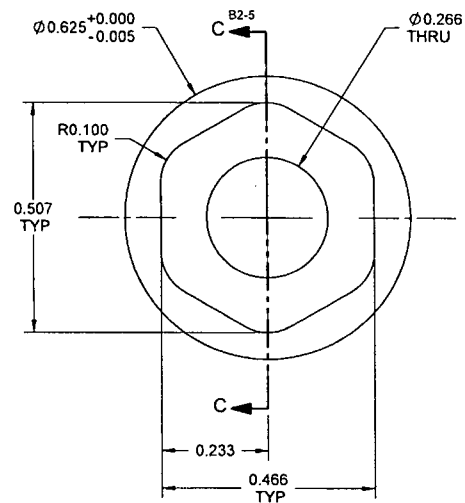
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
REF. DART SPEC. M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: LESS THAN 0.01 lbs EACH

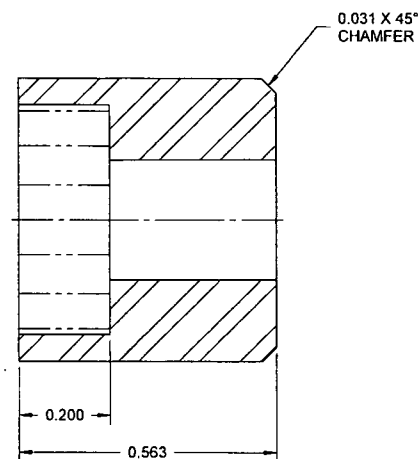
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MFG. APPR.	DS	D4013	SHEET 4 OF 5
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2009-11-24

53829



D4013-5 CUP



SECTION C-C D6-5

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC. M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs EACH

DESIGN	1	DART AEROSPACE LTD	
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APPROVED	1	TITLE	SCALE
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